

Date: Wednesday, 10/10/2007 11:03:47 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR PROTECTOR AFT LH
Job Number	: 35084	Part Number	: D32813
Estimate Number	: 11228	Drawing Number	: D3281 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 10/10/2007 S.O. No. : N/A	Drawing Revision	: C LE 08.01.07
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 11/2/2007
Previous Run	: 33899	Type	: R&D THERMOFORMING
Written By	: <u>W</u>	Qty:	20 Um: Each
Checked & Approved By	: <u>W</u>		Qty 1
Comment	: Est Rev: A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 F6002 701 lexan black



Comment: Qty.: 4.3600 sf(s)/Unit Total : 87.2000 sf(s)
lexan black .125"

Material Batch # M106713

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



X 10

Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

DL 08.01.05

3.0 THERMOFORMING THERMOFORMING MACHINE



X 10.

Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 009

Dwg. Rev. C

Folio Rev. _____

DL 08.01.05

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



X 10

DL 08.01.05

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT LH

Job Number: 35084

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



x10

Comment: HAND FINISHING THERMOFORMING

ML 08.01.07

1) Trim to Finished Dimensions

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



x10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 08.01.07

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.01.07 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

08.01.07 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.07 (10)

Job Completion



08.01.07 (10)

POSITIVE RECALL

EFFECTIVE

08.10.12

AUTH

h

RELEASED

h

DATE

08.01.04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

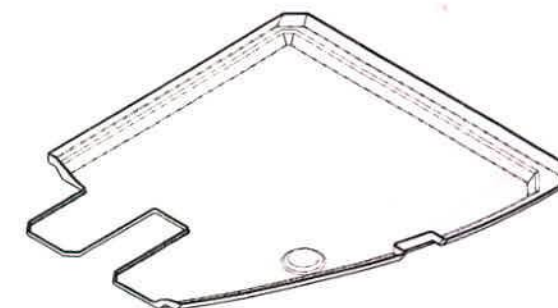
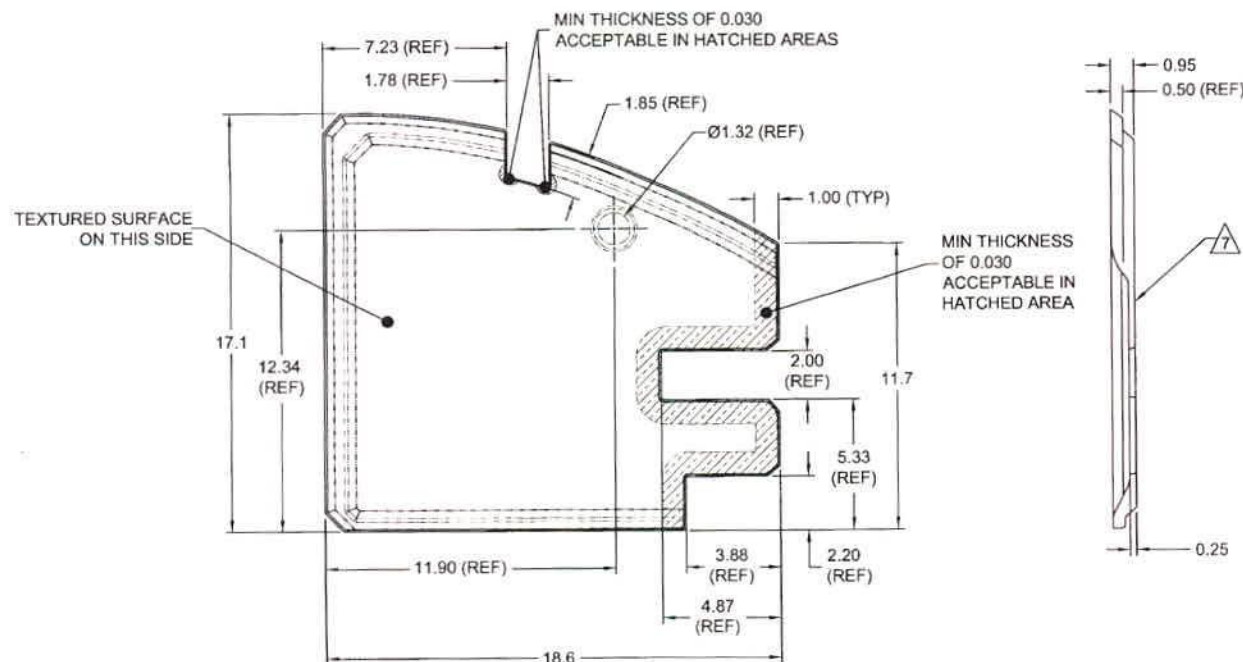
NOTE: Date & initial all entries

RELEASED
07.11.06

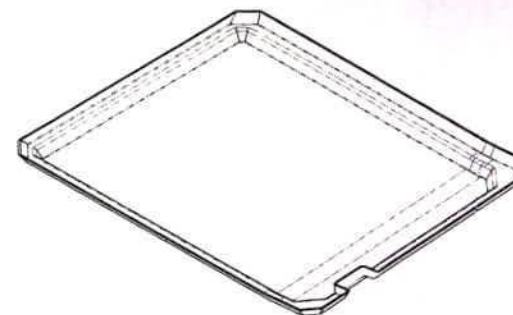
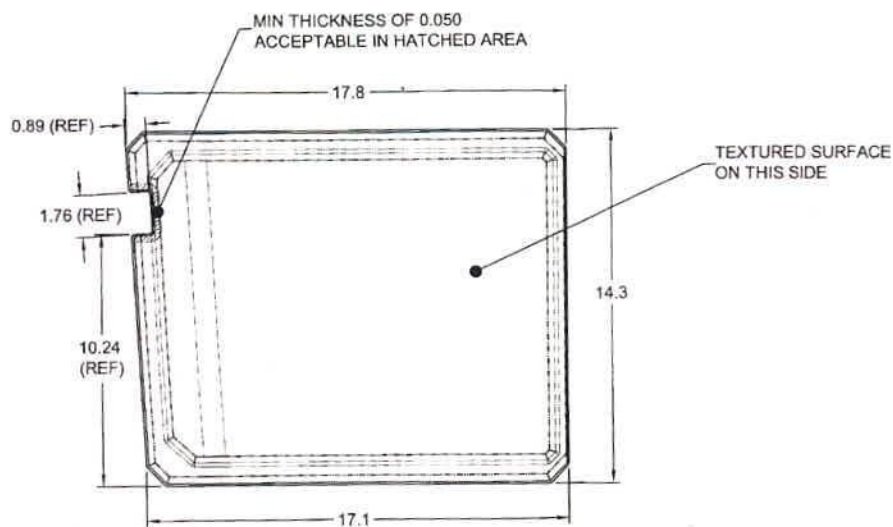
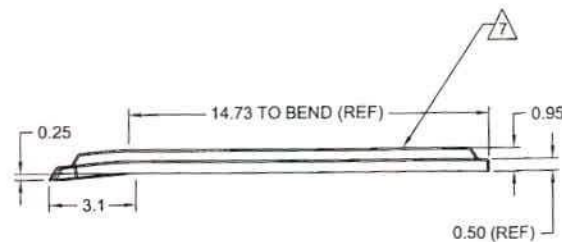
D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

D3281-1 FLOOR PROTECTOR



C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	LE	DRAWING NO.	REV. C
MFG. APPR.	LE	D3281	SHEET 1 OF 3
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	FLOOR PROTECTOR	NTS
DATE	07.10.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RELEASED
07-11-06

D3281-3 FLOOR PROTECTOR
(D3281-4 OPPOSITE)

W1035084

D3281-3/4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-3T1 FOR D3281-3 AND D3281-4T1 FOR D3281-4 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3/-4" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	90	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	WJP	D3281	SHEET 3 OF 3
APPROVED	WJP	TITLE	SCALE
DE APPR.	WJP	FLOOR PROTECTOR	NTS
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DART AEROSPACE LTD		Work Order: 35084
Description: R44 Floor Protectors RFT LH		Part Number: 03281-3
Inspection Dwg: 03281	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: D. Hoyle

Date: 08.05.01

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>17.8</u>	<u>.1</u>	<u>17.75</u>	✓			
<u>17.1</u>	<u>.1</u>	<u>17.1</u>	✓			
<u>14.3</u>	<u>.1</u>	<u>14.25</u>	✓			
<u>3.1</u>	<u>.1</u>	<u>3.1</u>	✓			
<u>0.95</u>	<u>.03</u>	<u>0.97</u>	✓			

Measured by: D. Hoyle

Date: 08.01.07

Audited by: [Signature]

Date: 08.01.07

Prototype Approval: NIA [Signature]

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

[Signature]